

SPUT

Dart Aerospace Ltd.

Date: Friday, 5/25/2007 8:30:45 AM
User: Kim Jobbston

Process Sheet

POSITIVE RECALL

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM	EFFECTIVE	07.06.05	AUTH	gp
Job Number	: 32646			RELEASED	07.06.06	DATE	gp
Estimate Number	: 12883						
P.O. Number	: N/A	Part Number	: D3560043				
This Issue	: 5/25/2007	S.O. No.	: N/A	Drawing Number	: D3560 REV.B		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: N/A	Type	: SMALL / MED FAB	Drawing Revision	: B		
Previous Run	: N/A			Material	: N/A		
Written By	: [Signature]	Due Date	: 6/5/2007	Qty:	30	Jty:	Each
Checked & Approved By	: [Signature] 07.05.25						
Comment	: Est Rev.A New Issue 07.05.24 EC						

Additional Product			
Job Number: [Barcode]			
Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"	
	[Barcode]	[Barcode]	
Comment: Qty.: 1.3598 f(s)/Unit Total: 40.7925 f(s) 6061-T6 Bar 0.50" x 5.00" Batch: 7635 x 3065 MK04598 X 7 36 07.06.05 10			
2.0	BAND SAW	BAND SAW	
	[Barcode]	[Barcode]	
Comment: BAND SAW Cut blanks 15.500" long 36 07.06.05 10			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
	[Barcode]	[Barcode]	
Comment: HAAS CNC VERTICAL MACHINING #1 1-Mill as per Folio FA695 Rev: AA & Dwg D3560 Rev: B 2-C'sink 0.196" hole on manual mill as per dwg D3560 3-Deburr per dwg D3560 31/36 07.06.05 10			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	[Barcode]	[Barcode]	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE 31/36 07.06.05 10			
5.0	QC8	SECOND CHECK	
	[Barcode]	[Barcode]	
Comment: SECOND CHECK 7/12 07.06.05 10			

Date: Friday, 5/25/2007 8:36:45 AM
User: Kim Johnston

Process Sheet

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Drawing Name: ARM

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Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)
PLATE 3.32641

JE 07-06-06 (5)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

JE 07-06-07 (5)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JE 07-06-07

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

JE 07/06/07 (5)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 07-06-07

5

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

NO POWDER COAT.

SEE W/O CHANGE

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3



12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 07/06/07

(5)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 07/06/07

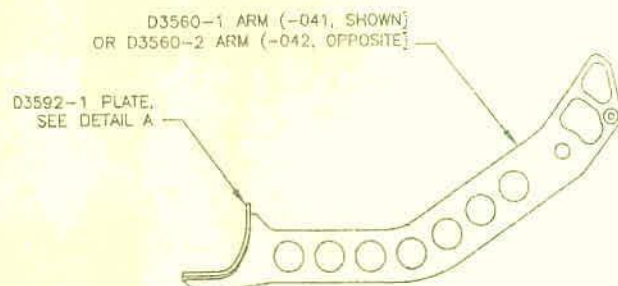
(5)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.06.05	13.5	PRESS FIT QTY(1) D2808 AFTER POWDER COAT SEE ATTACHED DS EMAIL. b 28000				07.06.05 per QS 042	07.06.12	
07.06.05	11	No powder coat. Will be powder coated after assembly in D3562 STEP WELDMENT. REF ATTACHED DS EMAIL.				07.06.06 per QS1042	07.06.12	

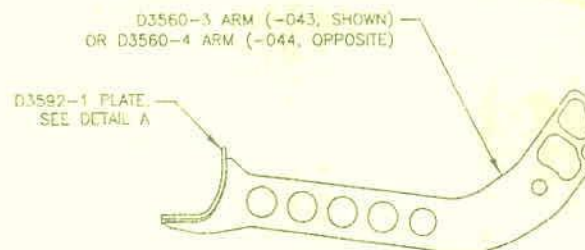
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 07.06.12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/12	3	- 1 part c-bore .507x.250 deep is actually .265 deep, is part acceptable	QS1042	Acceptable	J.L 07/06	07.06.12.	07.06.12	07.06.12

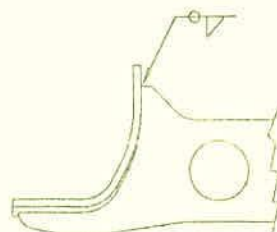
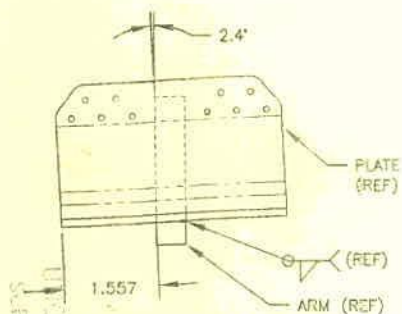
NOTE: Date & initial all entries



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 004 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

07 05, 07

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B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	q7	DRAWN BY q7
CHECKED	q7	APPROVED q7
DATE	07.01.15	TITLE
		ARM WELDMENT
		DART AEROSPACE LTD. BARRISBURGH, ONTARIO, CANADA
		DRAWING NO. D3560
		REV. 6
		SHEET 1 OF 3
		SCALE 1:4

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Drawing Name: ARM

Job Number: 32646

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description:

140

QC21

FINAL INSPECTION/W/O RELEASE



3/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion:



POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED U DATE 07/06/12

U 07-06-12

07/06/12

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: June 5, 2007 5:18 PM
To: 'Chris Provencal'
Subject: RE: D3562-041/-042

As we have discussed previously, this is acceptable as long as the Magnabond doesn't break down.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Tuesday, June 05, 2007 11:00 AM
To: David Shepherd (David Shepherd)
Subject: D3562-041/-042

David,

For the D3562-041/-042 step weldment, as discussed. They want to switch from Sikaflex to Magnabond, and powder coat after final assembly.

As part of this change, the D3560-XX arms won't be powder coated, and the D2808 Bushing won't be assembled until after final assembly of the step weldment.

Since this is the first time trying this, we will ensure that the steps are checked after powdercoating in case the Magnabond does anything unexpected (eg. bubbling). If we see anything suspect, we will assemble them the old way.

Is this acceptable.

-Chris

No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

